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RBT400214
Job Sheet 181707



Part No: RBT400214

Job Qty: 3 ea

Part Name: Trim Tab Bending Gauge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/18

Job Tracking No:

Due Date: 11/5/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400214 Rev. 7 IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/5/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs		11/5/18	0.00	1.00	Small Fab-9		MLL DAS 38
110	QC	1 pcs		11/5/18	0.00	0.00	QC5		9-89
120	Packaging	1 pcs		11/5/18	0.00	0.00	Packaging3-2		MLL 9-89
130	QC21-FG	1 Ea		11/5/18	0.00	0.00	QC21		DEC 11 2018

Part Op 100 - Assemble Per Drawing; 1-Cut -13 and -19 tape as per DWG. 2-APPLY -19 TAPE FOR SPRING CLIP TO -5
Descriptions: SPRING CLIP & -13 TAPE STOP TO -1 FRAME WELDMENT. 3-RIVET -3 DOUBLER & -5 SPRING CLIP TO -1 FRAME WELDMENT.
120 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
93878A146	Self Threading Pan Head Screw	9 Ea (3 ea)	90-Start up Operation	5032755
AN960-6	Flat Washer SEE PART NAS1149FN632P	9 Ea (3 ea)	90-Start up Operation	FM 137391
RBT400214-1	Frame Weld Mount	3 Ea (1 ea)	90-Start up Operation	1X5129276 2X5126755
RBT400214-17	Bearing 3/8 X 3/4" Black Nylon Or Delrin	9 Ea (3 ea)	90-Start up Operation	508680
RBT400214-3	Doubler	3 Ea (1 ea)	90-Start up Operation	5098828
RBT400214-5	Spring Clip	3 Ea (1 ea)	90-Start up Operation	5098823
76475A92	Low-Friction Surface-Protection Tape w/Teflon PTFE, Extra-Tough, 2" Wide x 0.022" Thick x 3' Long	.1660 ft (.166 ea)	90-Start up Operation	5068057
MS20470AD4-6	Rivet, Universal Head	4 Ea (4 ea)	90-Start up Operation	FM 133077-56



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Container No: S136262



Part: RBT400214

Job No: 181707

Serial No/Batch: S136262

Revision: 7

Inspector:

Exp Date:

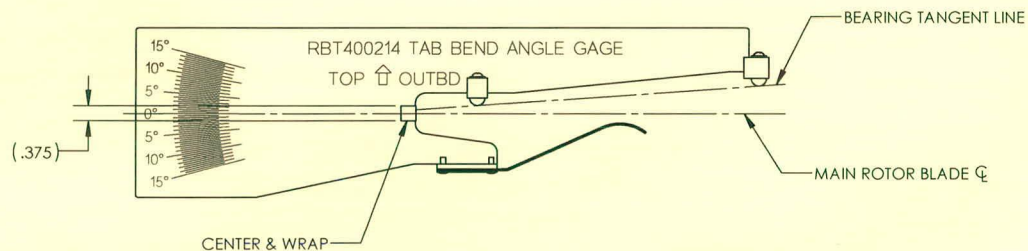
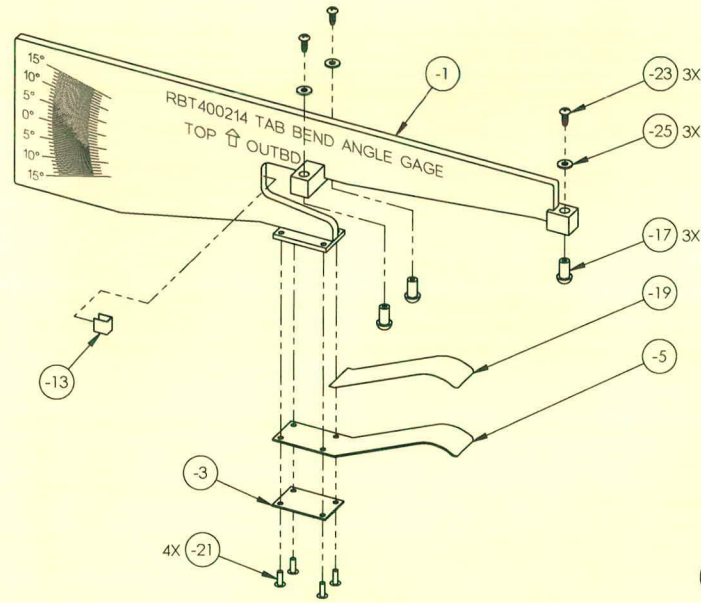
Instructions:

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	76475A92	0	3	0
	93878A146	3	100	0
	AN960-6	3	500	0
	MS20470AD4-6	4	998	0
	RBT400214-1	1	0	0
	RBT400214-17	3	28	0
	RBT400214-3	1	8	0
	RBT400214-5	1	8	0
Part Specifications				
Specifications could not be found.				

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			REVISIONS				
REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED	
			INSTALLED NEW TITLE BLOCK & BOM FORMAT, CHANGED P/N FROM 207-215-002-101, AND ALTERED FROM ONE 11x17 PAGE TO THREE 8x11 PAGES, ALSO ADDED HARDWARE AND ASSY. DWGS, CREATED -1 WELDMENT, ADJUSTED -11 POSITION UP .046 TO CORRECT ALIGNMENT.	10/30/2007	WP	RW	
2			MADE INTO FOUR PAGES, ADJUSTED BEARINGS UP .090 TO MATCH PURCHASED UNIT, -5 SPRING END WAS R1.125, & ADDED R.125 CORNERS, -11 GROOVE DEPTH WAS .186.	1/28/2008	WP	DW	
3			REPLACED ANGLE GAUGE ENGRAVING WITH A PLACARD, CREATED A POCKET FOR PLACARD IN FRAME PER S.E. SEPARATED PARTS TO INDIVIDUAL SHEETS, CHD FINISH FROM POWDER COAT SAFETY YELLOW, DELETED -7 FROM NOTE 2 ON SHEET 1.	4/27/2011	RJC	RW	
3A			ADDED B/O TO -19 IN BOM, CHD -1 FINISH FROM ANODIZE BLACK PER R.W.	8/25/2011	RJC	RW	
4			DELETED POCKET FOR -21 & REFERENCE MARKS, ADDED MACHINE ENGRAVE GAUGE LINES & LETTERING PER S.E.	6/28/2012	RJC	SE	
5			-9 & -11 CHD DIM WAS .250 IS .250 +.005/-0.000.	2/26/2013	BIM	SE	
6			-9 CHD DIM WAS .500 IS .530.	3/22/2013	BIM	GE	
7	16-0240		UPDATED TO NEW STANDARD, ADDED OEM REF, ADDED DASH NUMBERS TO B/O PARTS, -1 DELETED DIMS 15.250, 2.150, .089-.095, .203, 1.550, .694, (.190), ADDED DIMS 36, (.100), ADDED FEATURE RBT400214-1-F NOTE, -3 CHD DIMS WAS .040 IS .04, WAS 1.000 IS 1.00, WAS 1.500 IS 1.50, WAS 4X .0128 IS 4X .0128 +.005-.000, ADDED DIMS 2X .15, 2X .15, -5 CHD DIMS WAS 5.202 IS 5.20, WAS 1.190 IS 1.19, WAS 1.750 IS 1.75, WAS .040 IS .04, WAS 1.000 IS 1.00 WAS 4X .0128 IS 4X .0128 +.005-.000, WAS 2X R.125 IS 2X R.125, WAS (.455) IS (.455), WAS 1.200 IS 2X 1.200+.005, WAS .700 IS 2X .700+.005, WAS .150 IS 2X .15, DELETED DIM (.587), ADDED DIM 2X .15, CHD TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03, -7 CHD DIMS WAS .125 IS .13, WAS 4X .0128 IS 4X .0128 +.005-.000, WAS 1.000 IS 1.00, WAS 1.500 IS 1.50, WAS .700 IS 2X .700, WAS 1.200 IS 2X 1.200, ADDED DIMS 2X .15, 2X .15, -9 CHD DIMS WAS .500 IS .50, WAS .530 IS .53, WAS .250 +.005-.000 S.F., -13 IS 262-267 (S.F., -15), WAS .425 IS .43, WAS .500 IS .50, WAS .0125 IS .0125-.01, THRU ALL (S.F., -17), -11 CHD DIMS WAS .500 IS .50, WAS .500 IS .50, WAS 2.000 IS 2.00, WAS .250 +.005-.000 S.F., -13 IS 262-267 (S.F., -15), WAS 2X .0125 IS 2X .0125-.01 (S.F., -17), ADDED DIMS 2X .25, 2X .25, -13, -19 ADDED B/O REF (PORT PLASTICS #6093-10, ADDED DRAWING, -18 CHD DIMS WAS 3X R.040 IS 3X R.04, WAS 4.250 IS 4.25, WAS 3.000 IS 3.00, WAS 6.940 IS 6.94, WAS R4.400 IS R4.40, WAS R4.650 IS R4.65, WAS R4.900 IS R4.90, WAS .032 IS .03, WAS 2.040 IS 2.04, WAS 5.857 IS 5.86, WAS .500 IS .50, WAS 1.100 IS 1.10, WAS 15.250 IS 15.25, WAS .250 IS .25, WAS R.250 IS R.25, WAS 1.875 IS 1.88, WAS 1.375 IS 1.38, WAS 1.000 IS 1.00, WAS .032 IS .03, DELETED DIM 1.021, ADDED DIM .991, ADDED ENGRAVE S/N, "MADE IN USA" NOTE, -17 CHD MATL WAS BLACK NYLON OR DELRIN IS BLACK NYLON/DELIRIN/ACETAL, CHD DIMS WAS .460 IS .46, WAS .0125 IS .0125-.01 (S.F., -9 & -11), WAS .0110 IS .0110 ±.01, WAS R.190 IS R.190 IS SR.19, ADDED DIM .190, -19 WAS B/O IS MANUFACTURED, -23 ADDED B/O REF #93878A146.	12/1/2016	DPD	JAG	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X	-1	1	1	FRAME WELDMENT			1
		-3	1	1	DOUBLER	301 S.S.		3
		-5	1	1	SPRING CLIP	301 S.S.		4
1		-7			TAB	6061		5
1		-9			ADAPTER	6061		6
1		-11			ADAPTER	6061		7
		-13	1	1	TAPE STOP	TEFLON	(PORT PLASTICS #6093-10) MODIFIED	8
		-15			FRAME	6061		9
		-17	3	3	BEARING	BLACK NYLON/DELIRIN/ACETAL		10
		-19	1	1	TAPE FOR SPRING CLIP	TEFLON	(PORT PLASTICS #6093-10) MODIFIED	11
		B/O	-21	4	RIVETS	ALUMINUM	Ø1/8 X 3/8 (AN470AD-4-6)	1
		B/O	-23	3	SELF THREADING PAN HEAD SCREW	STEEL	6-32 X 3/8 (MCMASTER-CARR #93878A146)	1
		B/O	-25	3	FLAT WASHER	STEEL	#6 (AN960-6)	1
ASSY	-1							

- NOTES:
1. APPLY -19 TAPE FOR SPRING CLIP TO -5 SPRING CLIP & -13 TAPE STOP TO -1 FRAME WELDMENT.
 2. RIVET -3 DOUBLER & -5 SPRING CLIP TO -1 FRAME WELDMENT.
 3. REF. BELL T/N: 407-215-002-101.

DART AEROSPACE	
TITLE TRIM TAB BENDING GAUGE	
DWG NO. RBT400214	REV 7
MATL. _____ TREAT _____ FINISH _____ SPEC _____ UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES ± 125° 1. BREAK ALL SHARP EDGES .015 ± 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE CHECKED: CLOUGH SWPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL BELL 407	
SCALE 1:3	DATE 4/9/2001
SHEET 1 OF 11	

